

# Work Order ID 51399

August 21, 2009 9:03:52 AM



Page 1

Item ID: D3368-1 **FR**

Accept



Setup Start



Revision ID: B

Stop



Item Name: Pedal Lock Base

Start Date: 24/08/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 04/09/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3368	Rev B								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

*DTT 09/08/23*

*6*

HAAS CNC vertical machine #1

Machine D3368-1 as per Folio FA499 and Dwg D3368  
1 ☐ Debur

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

*DTT 09/08/23*

*6*

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

*JL 09/08/24*

Quality Control

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Start Date: 24/08/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 04/09/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

HL 09/08/25

6

Ø

HandFinish

Memo

0.00

Hand Finishing

140

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00

M102391

=> HL 09/08/26

6

Ø

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:15 AM OVEN TEMPERATURE:  
8:45 FINISH TIME: 320°F

150

QC3- Inspect Part Finish

0.00

PR 09-08-26

6

QC

Memo

0.00

Quality Control

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Item ID: D3368-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Pedal Lock Base

Start Date: 24/08/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 04/09/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: y9w

0.00



Packaging

Memo

0.00

Packaging

09/08/22 (6)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/28 (2)09-8-27

# Picklist Print

Page 1

August 21, 2009 9:03:51 AM

Work Order ID: 51399



Parent Item: D3368-1RevB



Parent Item Name: Pedal Lock Base

Start Date: 24/08/2009

Required Date: 04/09/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	19.9079	5.5800			



6061-T6 Bar 2.00 x 2.00

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	19.90786316	
110167	2.36	
13085	12	
17124	5.54786316	

~~1.828~~ 1.828  
~~3.157~~ 3.157  
 09/08/21

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 51399
<b>Description:</b> Pedal Lock Base		<b>Part Number:</b> D3368-1
<b>Inspection Dwg:</b> D3368	<b>Rev:</b> B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.242	✓			
7.250	+/-0.010	7.250	✓			
0.107	+/-0.010	0.110	✓			
1.800	+/-0.010	1.794	✓			
0.750	+/-0.010	0.752	✓			
Ø1.031	+/-0.010	1.031	✓			
45°	+/-0.5°	45°	✓			
0.250	+/-0.010	0.245	✓			
2.00	+/-0.030	1.990	✓			
7°	+/-0.5°	7°	✓			
Ø0.230	+0.005/-0.000	0.2305	✓			
1.250	+/-0.010	1.252	✓			
1.075	+/-0.010	1.077	✓			
R0.500	+/-0.010	0.500	✓			
0.375	+/-0.010	0.370	✓			
0.310	+/-0.010	0.306	✓			
1.450	+/-0.005	1.448	✓			
0.375	+/-0.010	0.370	✓			
5.125	+/-0.010	5.125	✓			
0.485	± 0.010	0.489	✓			

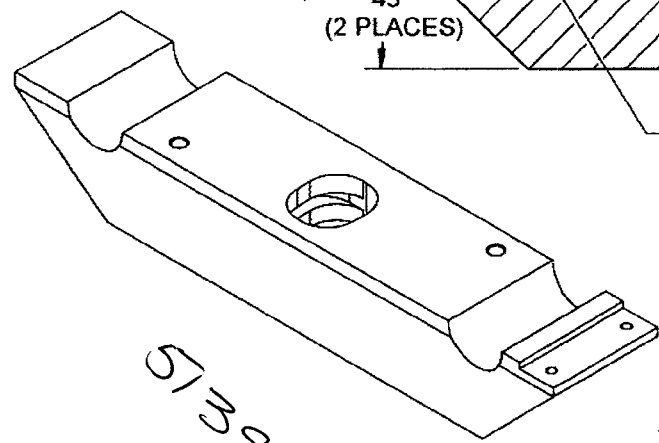
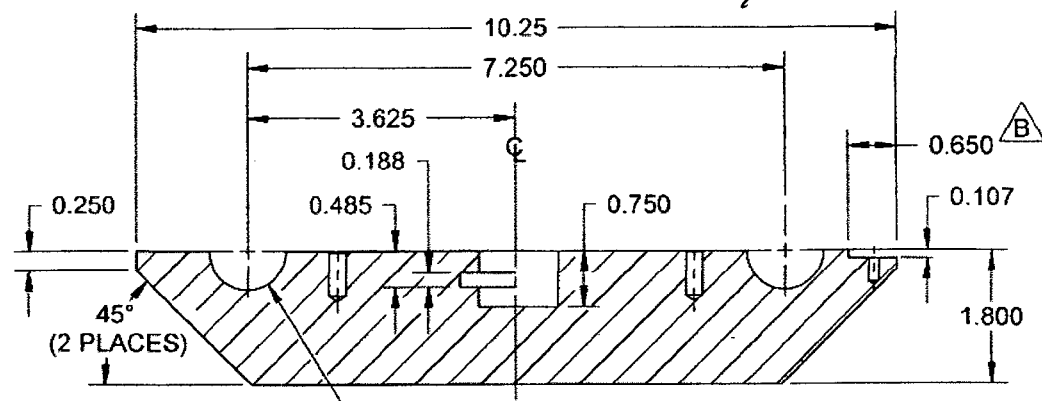
<b>Measured by:</b> DJP	<b>Audited by:</b> JL	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/08/23	<b>Date:</b> 09/08/24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	
C	08.07.23	0.700 dimension removed	KJ/DD	



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3368</b>	REV. B SHEET 2 OF 3
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:2.5

*w/o 51399*



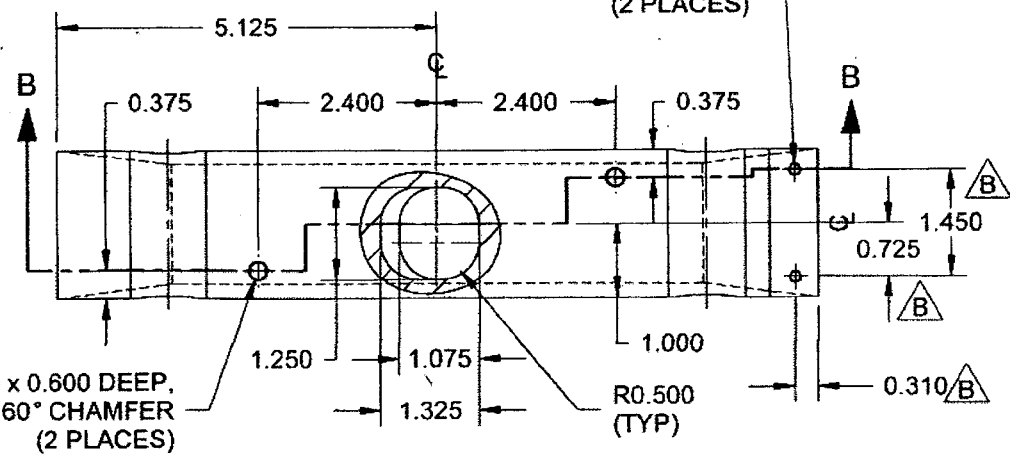
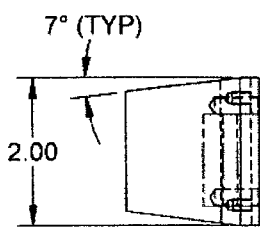
Ø 1.031  
(2 PLACES)

**SECTION B-B**

**RELEASED**  
*[Signature]*  
*05/04/20*

*51399*

**DRILL Ø0.136 x 0.300 DEEP,  
TAP 8-32 UNC TO BOTTOM OF HOLE  
(2 PLACES)**



**DRILL Ø0.230 x 0.600 DEEP,  
0.15 x 60° CHAMFER  
(2 PLACES)**

**D3368-1 BASE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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